

Work Order ID 63847

Tuesday, November 16, 2010 1:31:26 PM



Page 1

Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 11/16/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

10/11/10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D350-636

H

0.00

100



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

HJ LG BG 10-12-8

B63847

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8- Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10- Open up holes of Detail A to 0.297" (total of 2 holes per side)

BB

10/11/22

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch: ☐ m111305

12-Grind welds flush as per Dwg D2750

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8/10/11/13

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/11/13

(T0)

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 0 BE 10/11/24

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 BE 10/11/24

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☒ Sikaflex-291 batch: 116 040 ☐ ☐
exp. date: 11-9-30

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R ☐ Aluminum Rod batch: M111285

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

BE 10/11/29

BE 10/11/29

BE 10/11/29

10/11/25

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Run Start

Stop

Sequence ID/
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DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

dwg D2750

12-Deburr holes

BE 10/11/29

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00

=> M 10/12/01

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

M115951

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:35
OVEN TEMPERATURE: 320°
FINISH TIME: 11:05

1 BR 10-12-7

210

QC3- Inspect Part Finish

0.00

=> M 10/12/08

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

1 Ø

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220



HandFinish

Hand Finishing

HandFinishing

Memo

Install inserts as per dwg D2750

0.00

= JH

10/12/08

0.00

1

0

230



HandFinish

Hand Finishing

HandFinishing

Memo

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"
batch: PIA

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as
per dwg D2750

SIKA FLEX 241
BATCH: 1115114
EXP DATE: 11101

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch: 1114189

5-Coat all exposed fasteners with "LPS Procyon"
batch: 1114596

0.00

= JH

10/12/08

0.00

1

0

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

BR / M. M. 10-12-8.

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/12/BSL

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

MA 10 12 10 (11)

W/O:		WORK ORDER CHANGES					
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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

0.00



Packaging

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-012

280

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/12/13

10/12/14

11.12.14

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Picklist Print

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Page 1

Work Order ID: 63847



Parent Item: D350-636-012



Parent Item Name: Skin Tube RH

Start Date: 11/16/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07-13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC
 IPP Rev: M 08-04-22 update steps 4,13 DD verified by: EC
 IPP Rev: N 08-09-23 revF as per dwg DD verified by: ec IPP Rev: O
 10.06.22 revise seq 110 DD verf: EC IPP Rev: P 10.10.01 as
 per IIN revH DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-225 		Purchased	No			220	Each	4,520.000	38	38			
Insert													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				PK011		4520							
				110768		4520							
AN3C5A 		Purchased	No			230	Each	888.0000	34	34			
Bolt													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST350		878							
				114330		11							
				115015		13							
				115371		100							
				115422		100							
				115594		282							
				115835		372							
				ST351		10							
				113121		10							

11/16/2010

x38

11/16/2010

x34

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Start Date: 11/16/2010

Required Date: 11/30/2010

Start Qty: 1.00


Required Qty: 1.00

AN3C6A Purchased No 230 Each 245.0000 4 4

 BOLT

Location Loc Qty Loc Code

ST351 245

111982 245

AN6C44A Purchased No 230 Each 119.0000 4 4

 BOLT

Location Loc Qty Loc Code

FG 2

103964 2


ST344 117

111649 2

114653 1

114941 64

115936 50

AN8C35A Purchased No 230 Each 54.0000 1 1

 BOLT


Location Loc Qty Loc Code

ST346 54

114442 5

115188 22

115960 27

AN960C10L NAS1149C0332 Purchased No 230 Each 25.0000 38 38
R

 washer

Location Loc Qty Loc Code

ST245 25

107534 25

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Shop Packet Print

Page 2

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Parent Item Name: Skicube RH

Start Date: 11/16/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C816L

Purchased No

230 Each

0.0000

1 1



✓ NAS1149C08332R/M114915



x1 11/10/12/08

WASHER

D2745

Manufactured No

230 Each

265.0000

8 8



11/10/12/08

Bushing

Location

Loc Qty

Loc Code

ST023

265

52311

5

59112

4

61203

44

61988

104

63315

108

✓

D3488-042

Manufactured No

230 Each

24.0000

1 1



11/10/12/08

Blade Fitting Assembly, RH

Location

Loc Qty

Loc Code

FP008

15

59643

5

62003

10

FP18

9

61690

9

x1

D3492-041

Manufactured No

230 Each

76.0000

8 8



11/10/12/08

Plug Assembly

Location

Loc Qty

Loc Code

FP013

76

59114

1

61987

14

62210

61

✓

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Shop Packet Print

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Start Date: 11/16/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3492-043

Manufactured No

230

Each

85.0000

8

8



Plug Assembly

Location

Loc Qty

Loc Code

FP

2

54682

2

FP013

83

59117

1

59190

4

62663

78

X8

D3535-25

Manufactured No

230

Each

21.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP18

21

62033

7

62233

14

X1

D3536-25

Manufactured No

230

Each

4.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP12

4

B63857

X1

61707

4

D3537-1

Manufactured No

230

Each

27.0000

3

3



Wearpad

Location

Loc Qty

Loc Code

FP017

27

B63545

X3

62661

9

63313

18

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 5

Work Order ID: 63847

Parent Item: D350-636-012



Parent Item Name: Skidube RH

Start Date: 11/16/2010

Required Date: 11/30/2010



Start Qty: 1.00

Required Qty: 1.00

D3631-1 Manufactured No 230 Each 281.0000 8 8
 Washer
 10/12/08



Location	Loc Qty	Loc Code
ST072	281	
60755	81	
63647	200	

x8

D3672-1 Manufactured No 230 Each 667.0000 4 4
 Phenolic Washer
 10/12/08



Location	Loc Qty	Loc Code
ST077	667	
42329	10	
52505	657	

vd

D3791-1 Manufactured No 230 Each 19.0000 1 1
 Wearplate
 10/12/08

Location	Loc Qty	Loc Code
FP17	19	
61702	7	
62239	12	

x1

D3793-1 Manufactured No 230 Each 16.0000 1 1
 Wearshoe
 10/12/08

Location	Loc Qty	Loc Code
FP18	16	
59151	1	
59630	1	
61244	1	
61710	13	

yl

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, November 16, 2010 1:31:33 PM

Work Order ID: 63847

Parent Item: D350-636-012

Parent Item Name: SkidtLoe RH

Start Date: 11/16/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230 Each

13.0000 1



Wearshoe



1
10/12/08

Location

Loc Qty

Loc Code

FP18

12

61711

12

FP19

1

57947

1

X1

D3794-1

Manufactured No

230 Each

20.0000 1



Gasket



1
10/12/08

Location

Loc Qty

Loc Code

FP010

20

61704

20

X1

D3794-3

Manufactured No

230 Each

25.0000 1



Gasket



1
10/12/08

Location

Loc Qty

Loc Code

FP10

24

60826

1

61712

23

FP18

1

59153

1

X1

MS21043-6

Purchased No

230 Each

618.0000 4



NUT



4
10/12/08

Location

Loc Qty

Loc Code

ST301

618

112314

618

X4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 63847

Parent Item: D350-636-012

Parent Item Name: Skatube RH

Start Date: 11/16/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

87.0000

1

1



NUT

10/12/08

Location

Loc Qty

Loc Code

ST303

87

113845

5

114934

3

115594

29

115884

50

X1

NAS1611-010

Purchased

No

230

Each

309.0000

8

8



O-RING

10/12/08 PTO=>

Location

Loc Qty

Loc Code

FP

309

110715

100

110915

159

115589

50

NAS1611-013

Purchased

No

230

Each

228.0000

8

8



O-RING

10/12/08

Location

Loc Qty

Loc Code

FP

228

115460

100

115589

28

115812

100

X0

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Page 7

W/O 63847		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/12/08	230	Replace NAS 1611-010 "O" rings for D2594-3/M61762 "O" rings	jd	10/12/08	x8		

Part No: D350-636-012 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, November 16, 2010 1:31:33 PM

Page 8

Work Order ID: 63847

Parent Item: D350-636-012

Parent Item Name: Skidube RH

Start Date: 11/16/2010

Required Date: 11/30/2010

Start Qty: 1.00

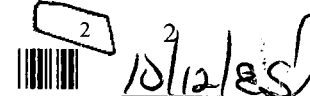
Required Qty: 1.00

AN8C21A

Purchased No 250 Each 45.0000



BOLT



Location Loc Qty Loc Code

ST345 45

113558 1

114653 4

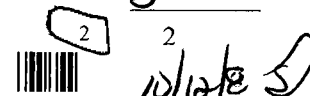
115723 40

Purchased No 250 Each 123.0000

AN960JD816



1/2" washer, Alum



Location Loc Qty Loc Code

ST348 123

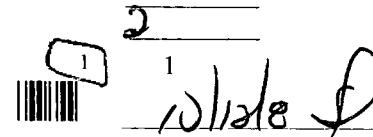
106043 123

Manufactured No 250 Each 25.0000

D2741



Blade, 350 Skidtube



Location Loc Qty Loc Code

ST466 25

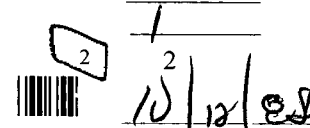
60210 25

Manufactured No 250 Each 36.0000

D3493-1



Washer



Location Loc Qty Loc Code

ST062 36

61672 36

Tuesday, November 16, 2010 1:31:33 PM

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 9

Work Order ID: 63847

Parent Item: D350-636-012

Parent Item Name: Sk...tube RH

Start Date: 11/16/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3532-1

Manufactured No

250

Each

47.0000



Spacer

2 10/12/10

Location

Loc Qty

Loc Code

ST065

47

61673

5

62218

42

D3672-13

Purchased

No

250

Each

792.0000



Phenolic Washer

2 2

Location

Loc Qty

Loc Code

ST077

792

54363

792

MS21083C8

Purchased

No

250

Each

87.0000



NUT

1 2 10/12/10

Location

Loc Qty

Loc Code

ST303

87

113845

5

114934

3

115594

29

115884

50

D2600-3-BENT

Manufactured

No

110

Each

13.0000



Extrusion Bent

1 1

Location

Loc Qty

Loc Code

LG

13

61634

4

62594

8

62764

1

1 10/11/10

Tuesday, November 16, 2010 1:31:33 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 10

Tuesday, November 16, 2010 1:31:33 PM

Work Order ID: 63847



Parent Item: D350-636-012



Parent Item Name: Sk.Jtube RH

Start Date: 11/16/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D2744

Manufactured No

110

Each

39.0000

1

1



Cap



Location

Loc Qty

Loc Code

LG

6

59198

6

ST

33

62715

33

1 BE 11/11/23

D2739

Manufactured No

160

Each

12.0000

1

1



350 I Beam



Location

Loc Qty

Loc Code

LG

12

62563

8

62688

4

1 BB 10/14/25

D2743

Manufactured No

160

Each

150.0000

8

8



Crossbolt Spacer



Location

Loc Qty

Loc Code

LG

150

50281

10

57953

2

59111

31

61844

107

~~2 62400~~ 8
2 61844 x8

BE 10/11/29

D3490-3

Manufactured No

160

Each

39.0000

4

4



Cross Bolt Spacer



Location

Loc Qty

Loc Code

LG

39

60294

1

62668

38

4

BE 10/14/29

Tuesday, November 16, 2010 1:31:33 PM

Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Tuesday, November 16, 2010 1:31:33 PM

Work Order ID: 63847



Parent Item: D350-636-012



Parent Item Name: Stdtube RH

Start Date: 11/16/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

95.0000

4

4



Cross Bolt Spacer

BE 10/11/29

Location

Loc Qty

Loc Code

LG

95

59424

3

61217

2

62450

90

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

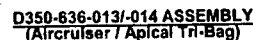
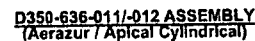
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

IIN-D350-636
Page 11 of 31

NO. 63847
28-11-14



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Revision: H
Date: 10.07.26

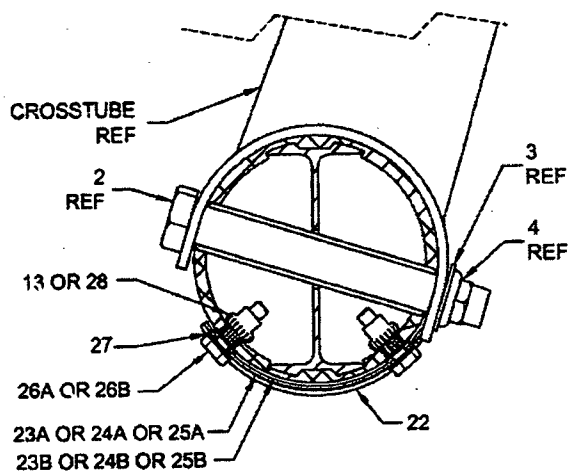
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

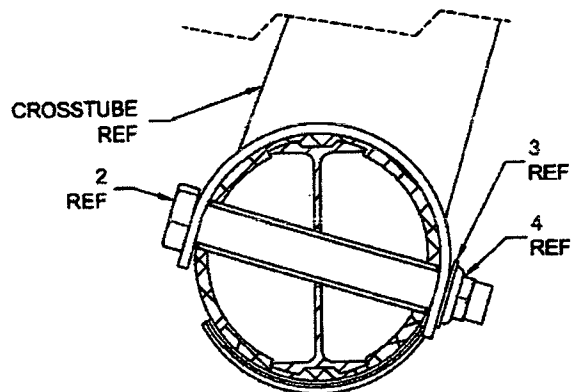
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



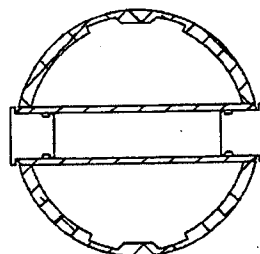
SECTION A-A

(D350-636-011/-012/-013/-014 SKIDTUBES
AT CHG 003 ONLY)



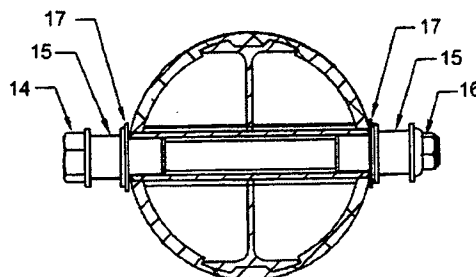
SECTION P-P

(D350-636-011/-012/-013/-014 SKIDTUBES
AT CHG 004 OR SUBSEQUENT)



SECTION B-B

(SECTION J-J, K-K, L-L AND M-M SIMILAR)
8 PL PER SKIDTUBE



SECTION C-C

4 PL PER SKIDTUBE

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Revision: H
Date: 10.07.26

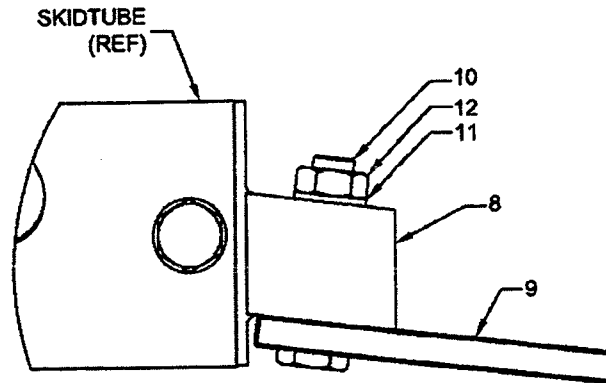
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

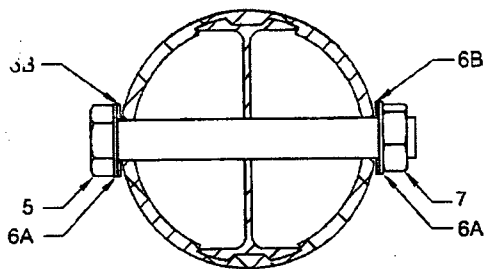
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

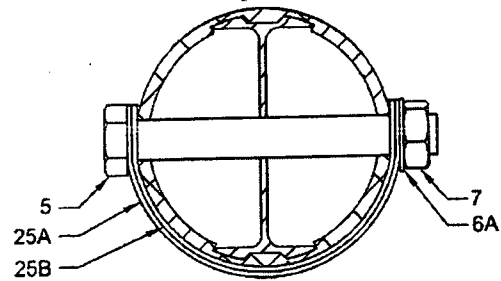
NOTE: Date & initial all entries



DETAIL D
1 PL PER SKIDTUBE

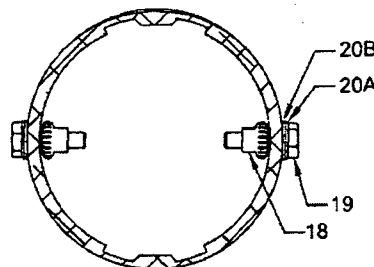


SECTION E-E
(D350-636-011/-012/-013/-014 SKIDTUBES
AT CHG 003 ONLY)



SECTION Q-Q
(D350-636-011/-012/-013/-014 SKIDTUBES
AT CHG 004 OR SUBSEQUENT)

with 63547



SECTION F-F
2 PL PER SKIDTUBE

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Revision: **H**
Date: 10.07.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C8A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

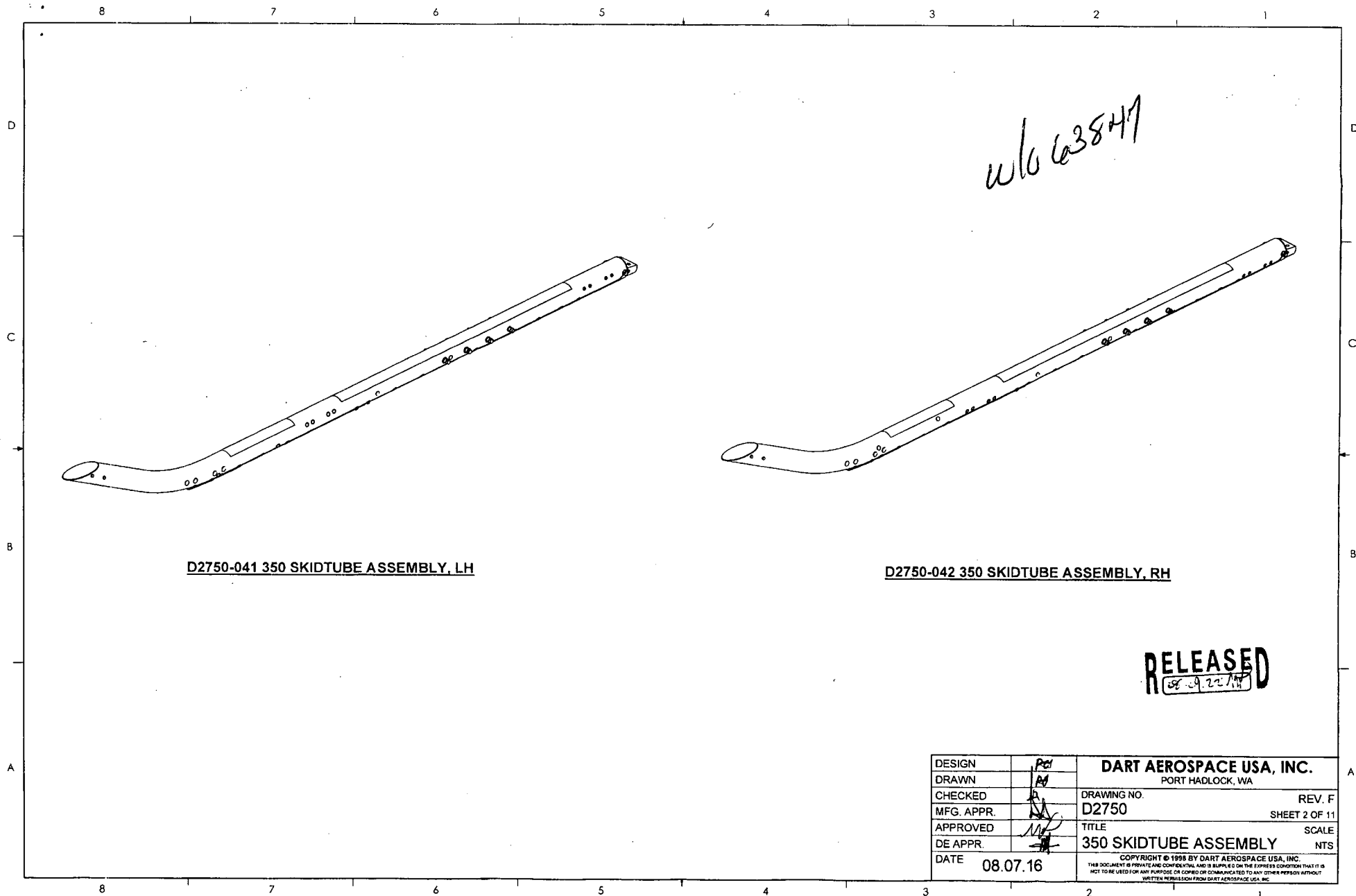
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 638217
BS 10-11-18

RELEASED
67-37-22 14P

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H6L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 5133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	REV. 1	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	REV. 1		
CHECKED	REV. 1	DRAWING NO.	REV. F
MFG. APPR.	REV. 1	D2750	SHEET 1 OF 11
APPROVED	REV. 1	TITLE	SCALE
DE APPR.	REV. 1	350 SKIDTUBE ASSEMBLY	NTS
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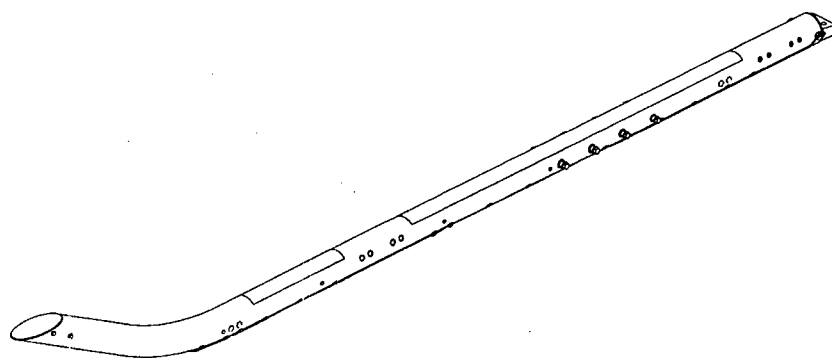
D2750-041 350 SKIDTUBE ASSEMBLY, LH

D2750-042 350 SKIDTUBE ASSEMBLY, RH

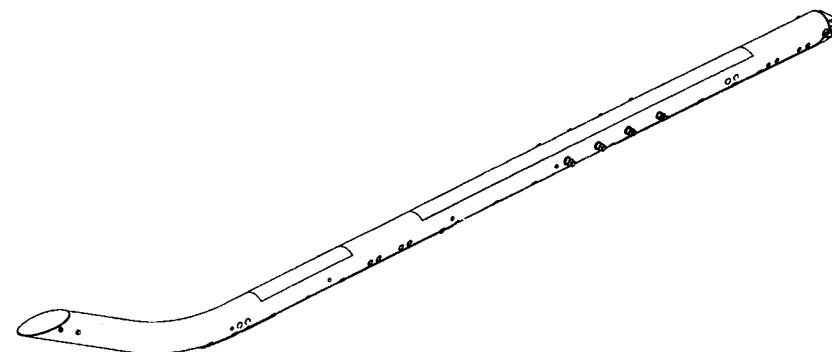
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68-09-22-1-11

DESIGN	PC1	DART AEROSPACE USA, INC.	
DRAWN	AM	PORT HADLOCK, WA	
CHECKED	SA	DRAWING NO.	REV. F
MFG. APPR.	MM	D2750	SHEET 2 OF 11
APPROVED	MM	TITLE	SCALE
DE APPR.	MM	350 SKIDTUBE ASSEMBLY	NTS
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w/o 63849



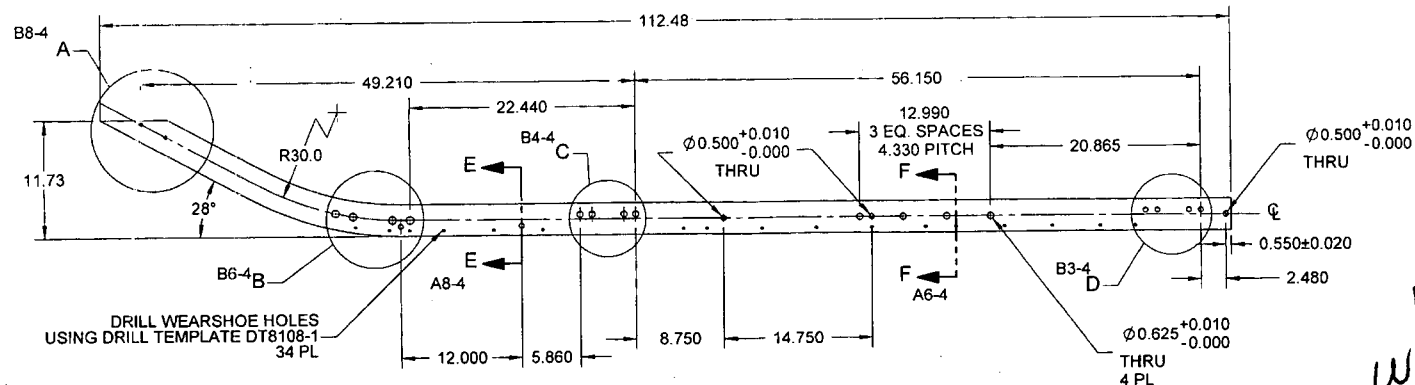
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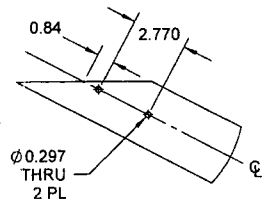
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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68-9-22/111

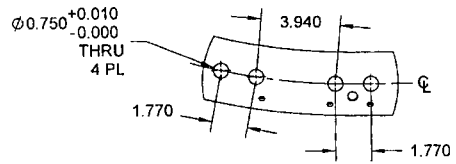
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DRAWN	PD	PORT HADLOCK, WA	
CHECKED	MA	DRAWING NO.	REV. F
MFG. APPR.	MA	D2750	SHEET 3 OF 11
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	350 SKIDTUBE ASSEMBLY	NTS
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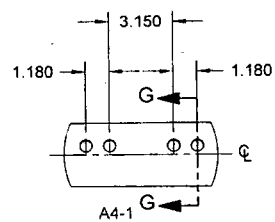
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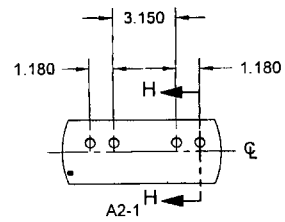
DETAIL A
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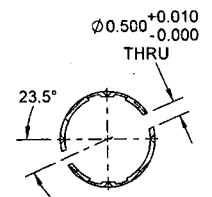
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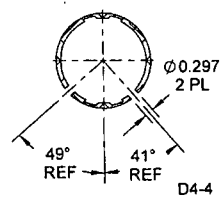
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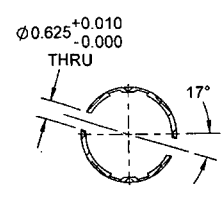
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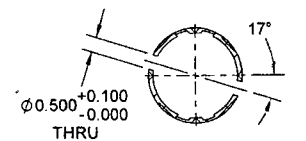
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



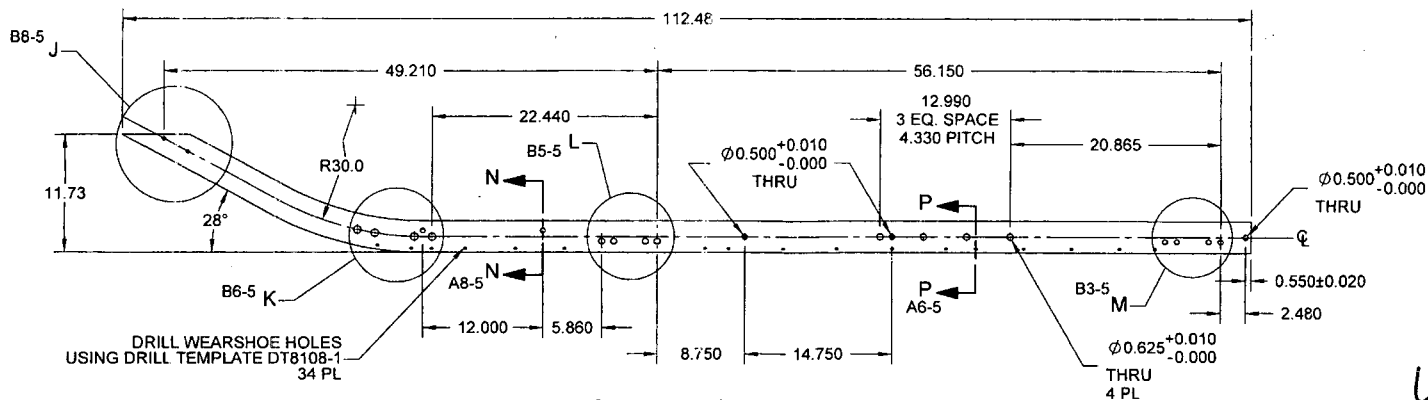
SECTION G-G
SCALE 3X, 4 PL



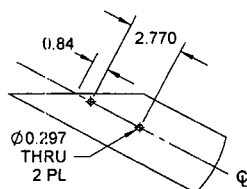
SECTION H-H
SCALE 3X, 4 PL

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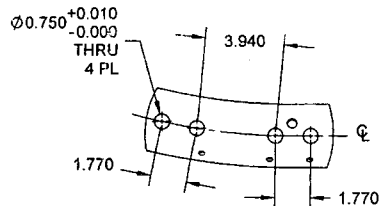
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MFG. APPR.		D2750	SHEET 4 OF 11
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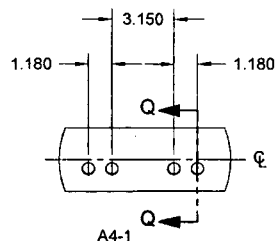
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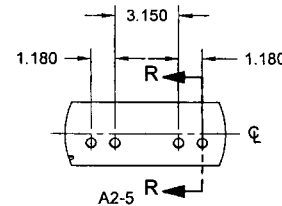
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SCALE 2X



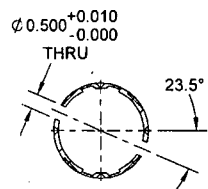
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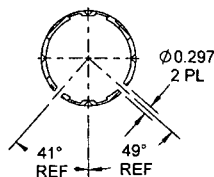
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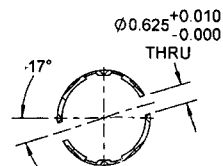
DETAIL M
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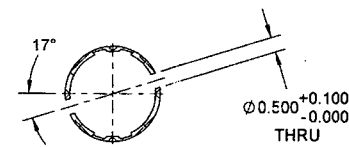
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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DESIGN	REV	DART AEROSPACE USA, INC.	
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7

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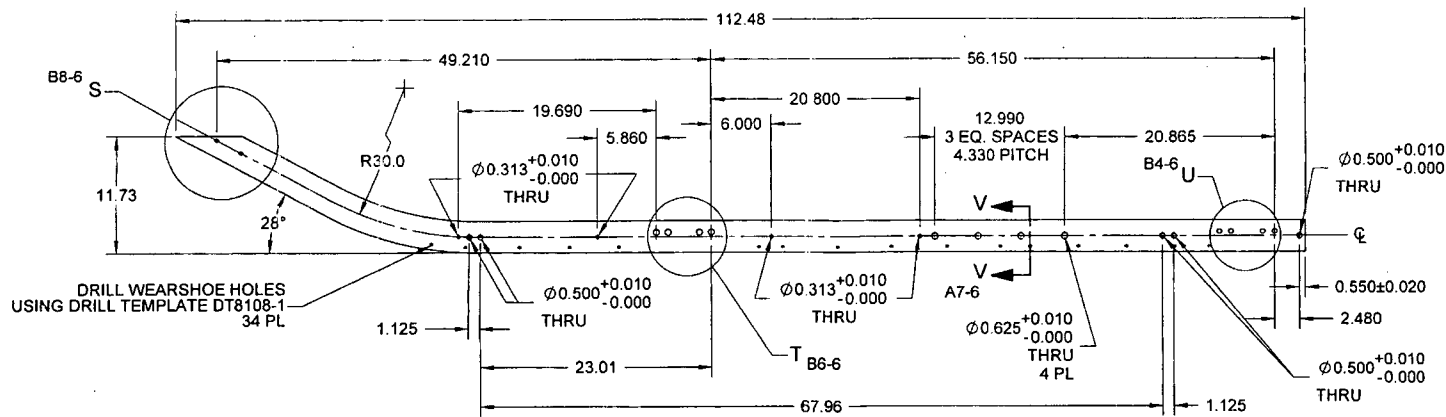
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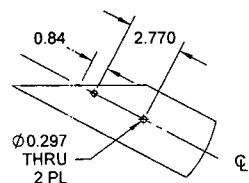
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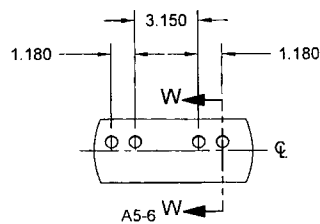
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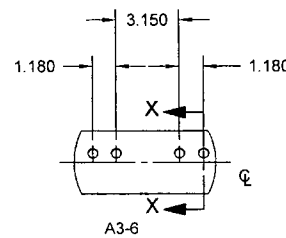
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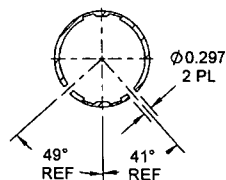
DETAIL S
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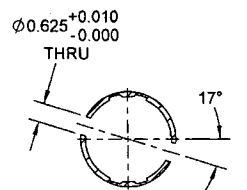
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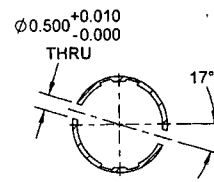
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

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MFG. APPR.		D2750	SHEET 6 OF 11
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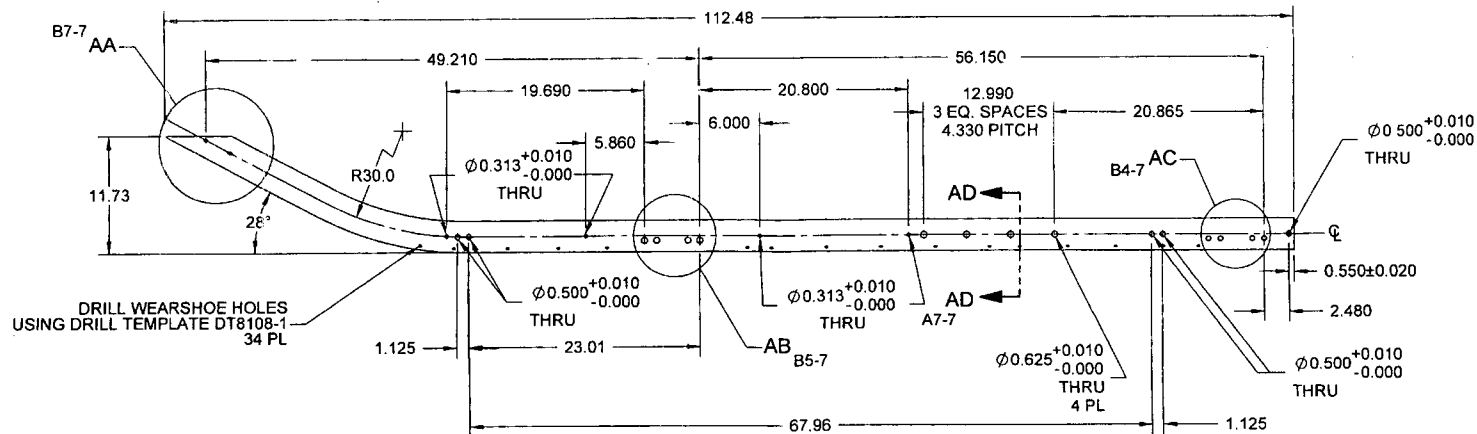
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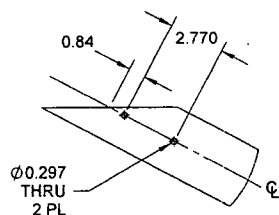
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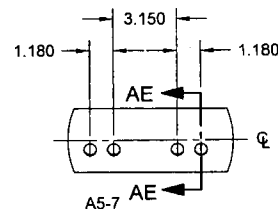
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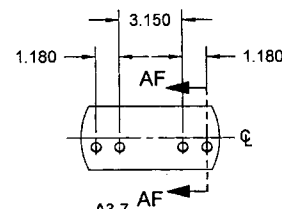
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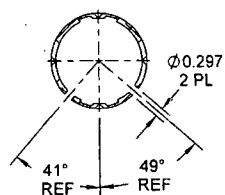
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SCALE 2X



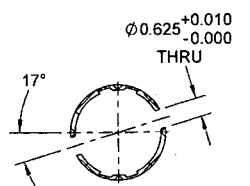
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SCALE 2X



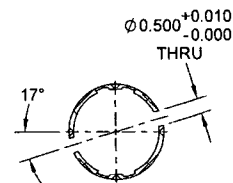
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL

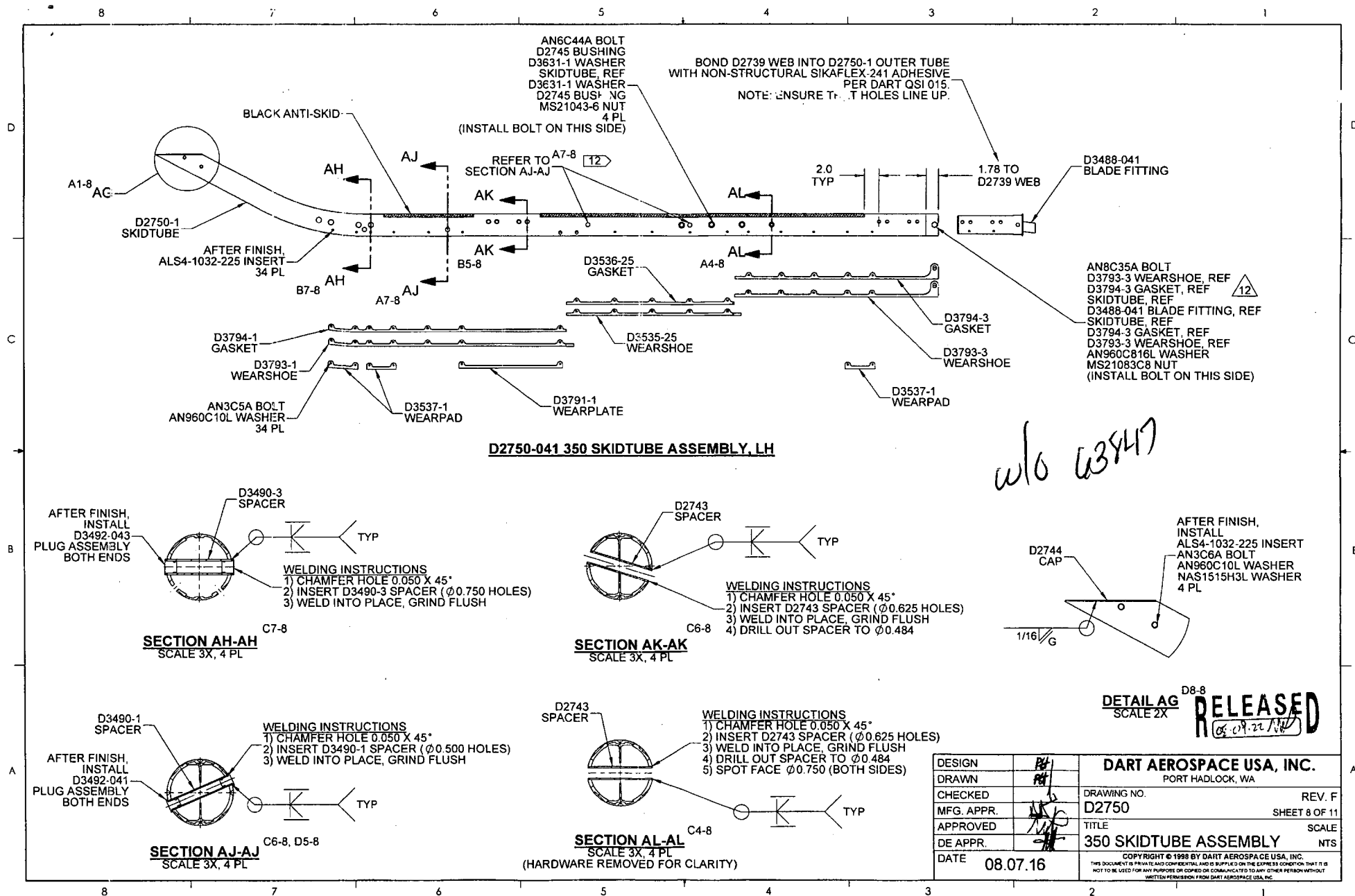


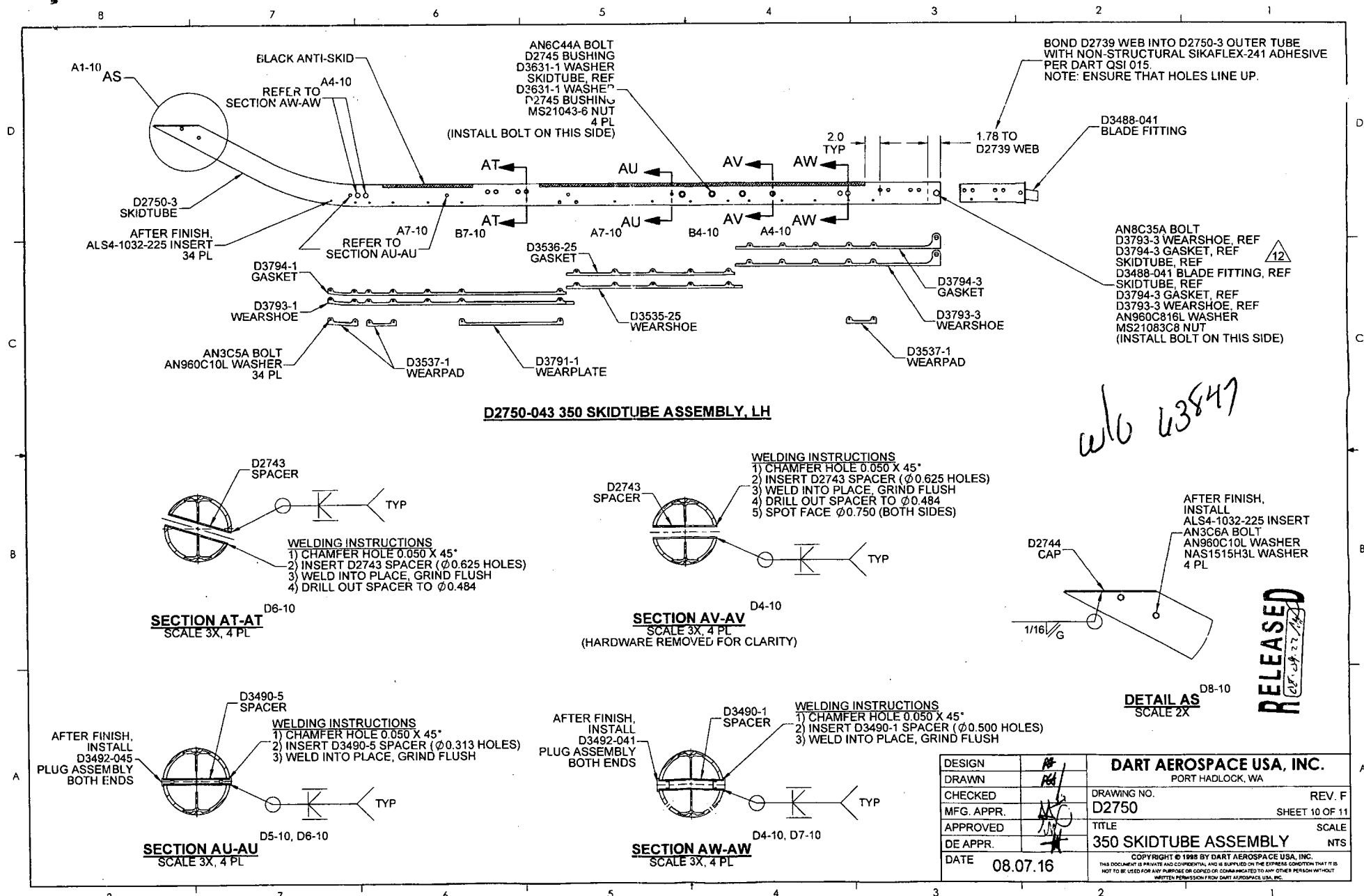
SECTION AF-AF
SCALE 3X, 4 PL

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DESIGN	<i>RA</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>RA</i>	PORT HADLOCK, WA	
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MFG. APPR.	<i>RA</i>	D2750	SHEET 7 OF 11
APPROVED	<i>RA</i>	TITLE	SCALE
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NO. 239

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: 6194 61914
Part number: D350.636.012
Description: 350 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier P.D. Date of Test Coupon 10.09.30
Welder Barday Elliott Date of Test Coupon 10.09.30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld